

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020296**Date Inspected:** 18-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Ping (ZPMC)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

Ultrasonic Testing (UT)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. All components were as listed on NWIT notification no. 07832. The member(s) is/are identified as Deck Plate to Deck Plate DP3162A (PL3438A), to DP3163A (PL3439A). The weld designations reviewed are as follows:

SEG3019-008

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OBG BAY 14

This QA observed one longitudinal indications in weld identified as SEG3019-008; Deck Plate DP3162A (PL3438A) to Deck Plate DP3163A (PL3439A) that did not appear to comply with the contract documents. This QA informed ZPMC QC identified as Mr. Lu Li Quing (CWI) and Zhan Hei Feng (QC) of this issue and that an incident report would be generated concerning this issue. For further details refer to the incident report issued by this QA on this date and the attached photos

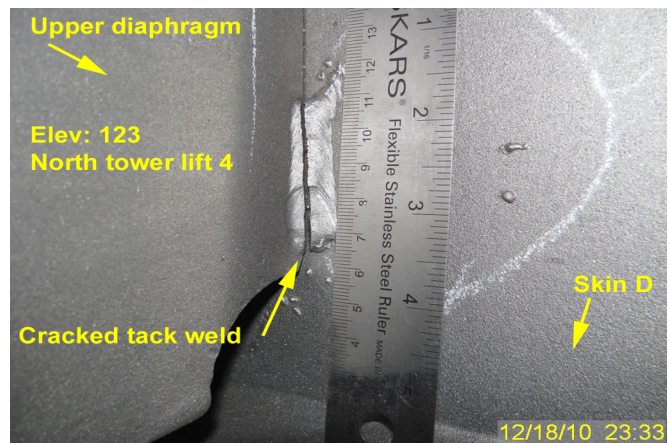
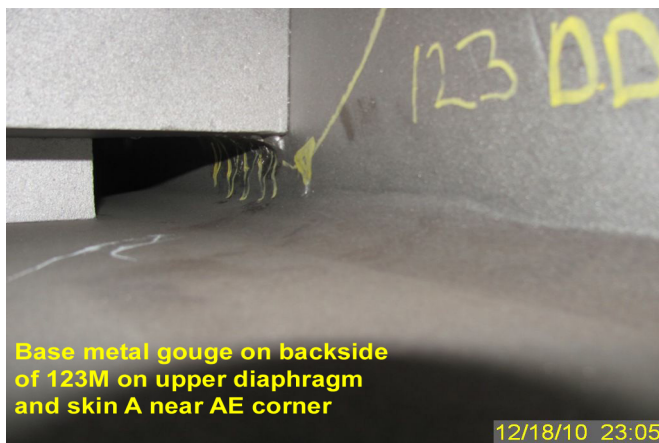
## BLASTING WELD SHOP No. 1

This QA inspector performed internal visual inspection of welds & base metal after blasting along with ZPMC and ABF Quality Assurance (QA) personnel. The member is identified as Tower Lift 4 – West Shaft from 116 meter to 131 meter. At 123 meter on Skin 'D' observed the following issues:

1. Crack temporary tack weld skin D, back side of 123M lower diaphragm.
2. Base metal gouge on back side of 123M upper diaphragm and skin A, near AE corner

For further details refer to the incident report issued on this date and the attached photos

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

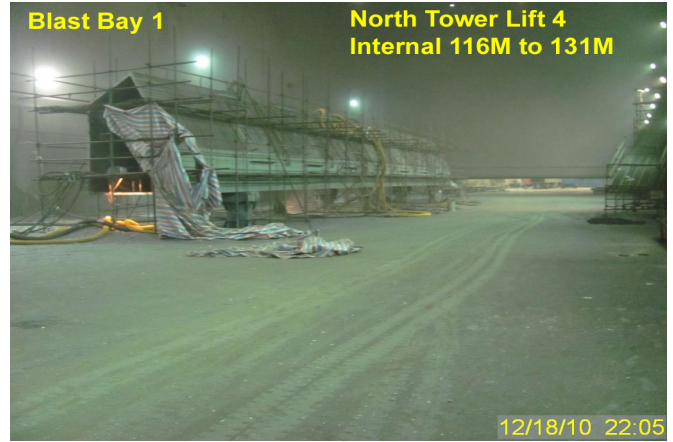
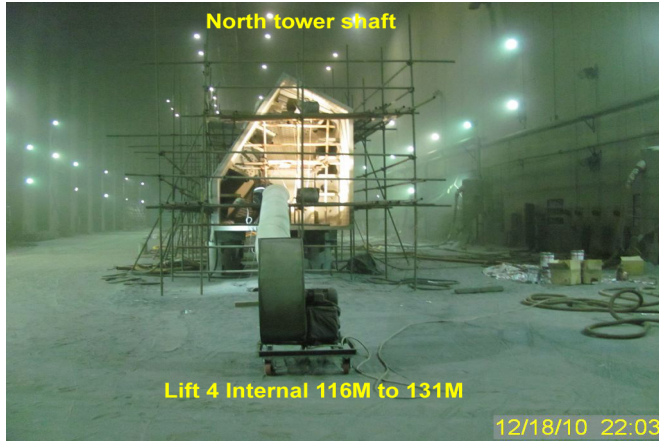


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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As mentioned above between QA and QC concerning this project

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	DeArmond,Robert
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken
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QA Reviewer
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